



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D3506-1**  
**Job Sheet 179645**



Part No: D3506-1

Job Qty: 40 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/6/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 06-05-31 JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation              | Qty    | Start Date | Due Date | Standard |      | Workcenter/Supplier   |           | Sign-off           |
|-------|------------------------|--------|------------|----------|----------|------|-----------------------|-----------|--------------------|
|       |                        |        |            |          | Setup    | Run  | Workcenter / Supplier | Lead Time |                    |
|       |                        |        |            |          | hrs      | Hrs  |                       |           |                    |
| 90    | Start up Operation     | 40 Ea  | 7/6/18     | 7/6/18   | 0.00     | 0.00 | Start Up Waterjet     |           | 18/06/22           |
| 100   | Waterjet               | 40 pcs | 7/6/18     | 7/6/18   | 0.00     | 1.19 | Waterjet1             |           | 18/06/22           |
| 110   | QC                     | 40 pcs | 7/6/18     | 7/6/18   | 0.00     | 0.00 | QC2 Waterjet-2        |           | 18/06/22           |
| 120   | CNC Vertical Machining | 40 pcs | 7/6/18     | 7/6/18   | 0.05     | 3.16 | HAAS1-3               |           | men L 18/07/11     |
| 130   | QC                     | 40 pcs | 7/6/18     | 7/6/18   | 0.00     | 0.00 | QC2 Machining-2       |           | 11                 |
| 140   | QC                     | 40 pcs | 7/6/18     | 7/6/18   | 0.00     | 0.00 | QC8 Machining-2       |           | 18/07/12           |
| 150   | Small Fab              | 40 pcs | 7/6/18     | 7/6/18   | 0.00     | 0.74 | Small Fab-4           |           | 38                 |
| 160   | QC                     | 40 pcs | 7/6/18     | 7/6/18   | 0.00     | 0.00 | QC5                   |           | 38                 |
| 170   | HandFinish             | 40 pcs | 7/6/18     | 7/6/18   | 0.00     | 0.70 | HandFinish1           |           | SA DAS 18-07-18    |
| 180   | QC                     | 40 pcs | 7/6/18     | 7/6/18   | 0.00     | 0.00 | QC7-2                 |           | 38                 |
| 190   | Packaging              | 40 pcs | 7/6/18     | 7/6/18   | 0.00     | 0.00 | Packaging3-1          |           | 9-89               |
| 200   | QC21-SA                | 40 Ea  | 7/6/18     | 7/6/18   | 0.00     | 0.00 | QC21                  |           | DAS 21 JUL 23 2018 |

### Job BOM

| Part / Item  | Component Name     | Quantity            | Operation             | Container |
|--------------|--------------------|---------------------|-----------------------|-----------|
| M6061T6S.100 | 6061-T6 .100 Sheet | .3120 sf (.0078 ea) | 90-Start up Operation | 5025078   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M6061T6S.100   | 0        | 44        | 0         |

### Part Specifications

Specifications could not be found.

Plex 6/20/18 1:41 PM dart.white.jesse



**Container No: S083322**



**Part: D3506-1**

**Job No: 179645**

**Serial No/Batch: S083322**

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions:**

**Dart Aerospace Ltd.**  
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**Date: 06/22/18**

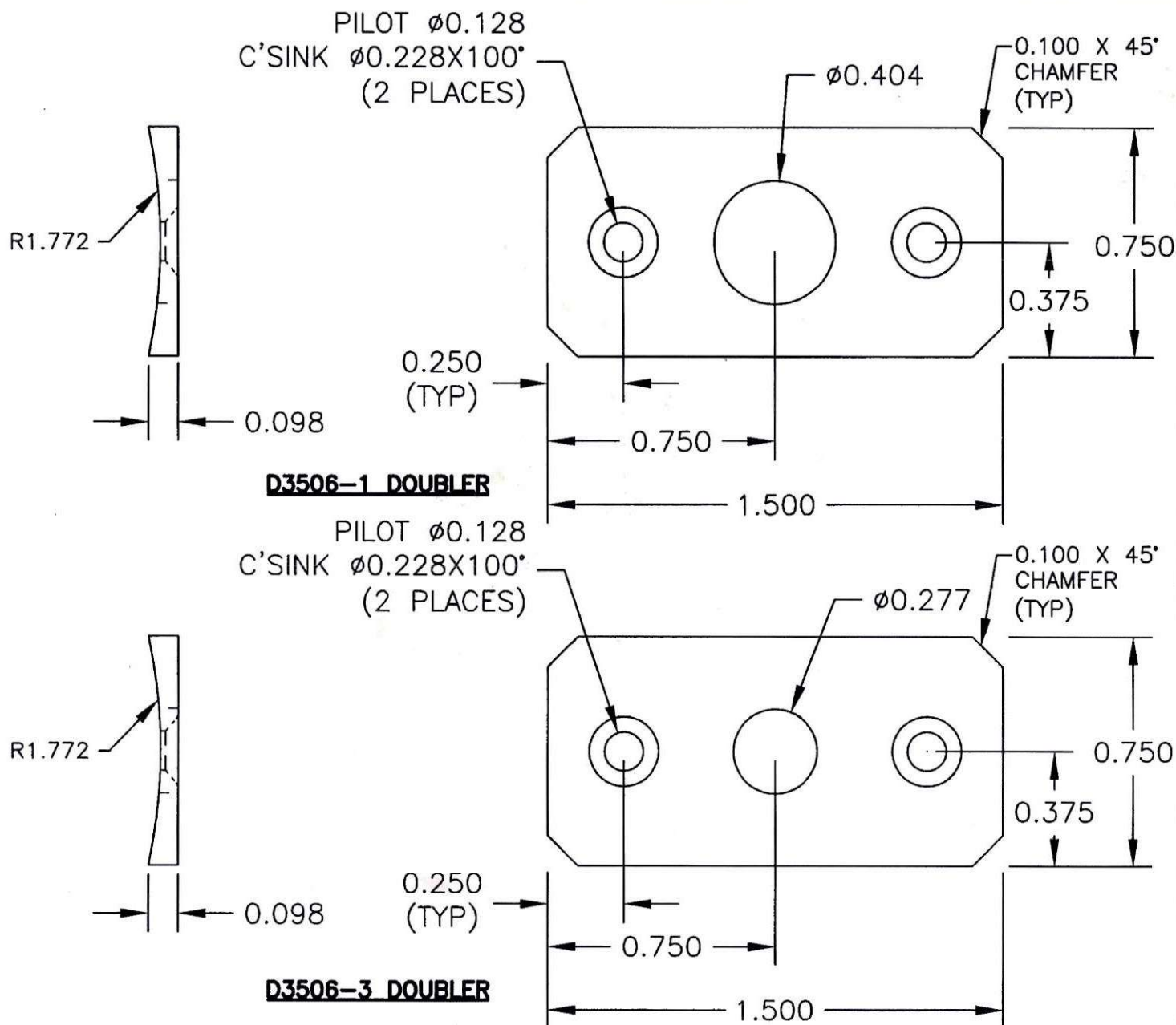
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**DART**

|                  |                |                                              |                        |
|------------------|----------------|----------------------------------------------|------------------------|
| DESIGN<br>PH     | DRAWN BY<br>PH | DART AEROSPACE USA, INC.<br>PORT HADLOCK, WA |                        |
| CHECKED<br>JH    | APPROVED<br>JH | DRAWING NO.<br>D3506                         | REV. A<br>SHEET 1 OF 1 |
| DATE<br>06.04.21 |                | TITLE<br>DOUBLER                             | SCALE<br>2:1           |
| A                | 06.04.21       | NEW ISSUE                                    |                        |

**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)  
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

**RELEASED**  
06.10.02 PH  
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